

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65847

Page 2

Wednesday, January 26, 2011 11:38:19 AM

Item ID: D3481-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle Bracket

Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3481

SB 11/01/27

(6)

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

S 11/01/27

(76)

150



Identify as per dwg & Stock Location: 062

0.00

Packaging

Memo

0.00

Packaging

Cud/01/28 (6)

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Page 3

Wednesday, January 26, 2011 11:38:19 AM

Item ID: D3481-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle Bracket

Start Date: 1/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/01/31 ME 11-01-28

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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 11:38:24 AM

Page 1

Work Order ID: 65847



Parent Item: D3481-3



Parent Item Name: Angle Bracket

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-02-07 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S26GA

Purchased

No

sf

98.8100

0.200100

.5



304/316 0.018 SHEET

B11-1-24

Location

Loc Qty

Loc Code

MAT20

98.81

109398

20.06

112885

78.75

112885

(6)

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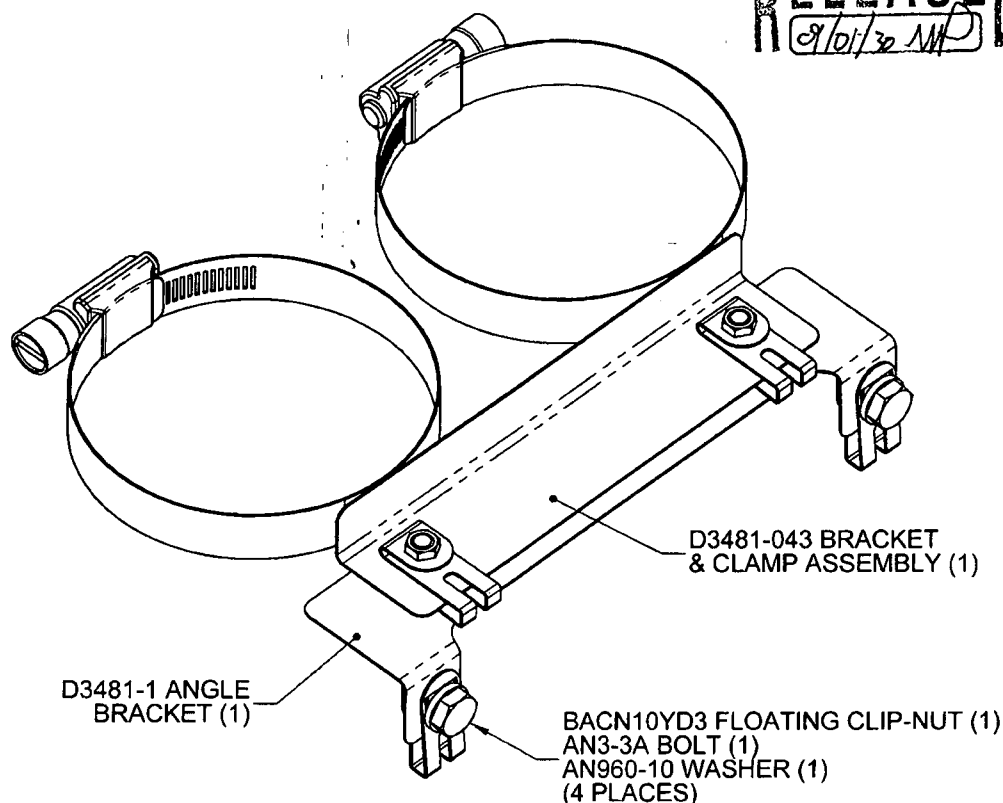
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. B SHEET 1 OF 4
DATE 08.12.19		TITLE SHUT-OFF VALVE BRACKET SCALE 2:3	
A	06.01.23	NEW ISSUE	
B	08.12.19	QS20052S WAS QS20056S (SHT 2); MATL SPEC WAS MIL-S-5019	

RELEASED
9/01/20 M/D



D3481-041 SHUT-OFF VALVE BRACKET

- 1) IDENTIFY WITH DART P/N D3481-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3481-041	SHUT-OFF VALVE BRACKET
1	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-1	ANGLE BRACKET
4	AN3-3A	BOLT
4	AN960-10	WASHER
4	BACN10YD3	FLOATING CLIP-NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43847

PH-01-26

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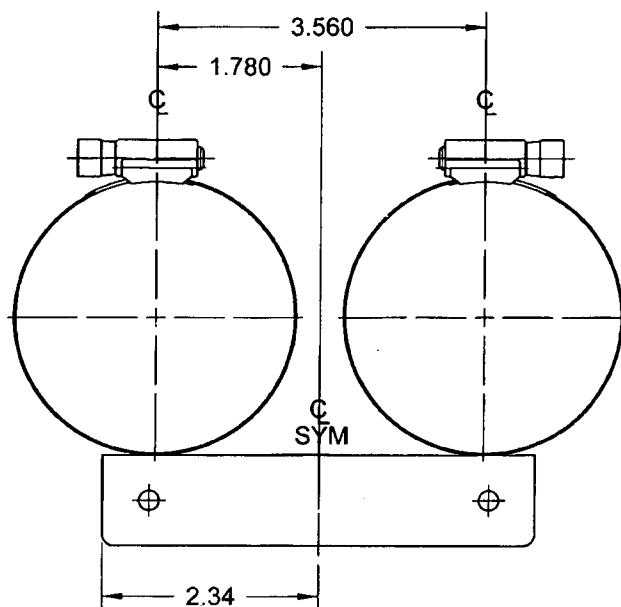
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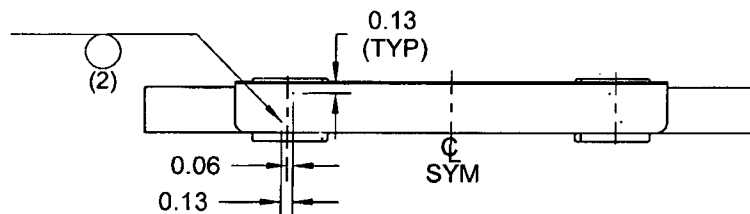
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CHECKED	APPROVED	DRAWING NO. D3481	REV. B SHEET 2 OF 4
DATE 08.12.19		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2



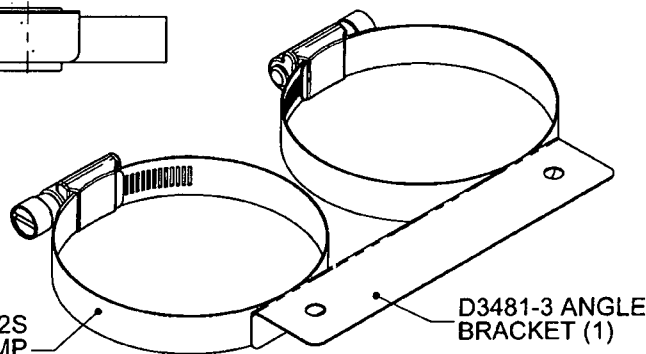
RELEASED
8/6/20 MP



u/065847



QS20052S
AERO-SEAL CLAMP
(2 PLACES)



D3481-3 ANGLE
BRACKET (1)

D3481-043 BRACKET & CLAMP ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010



QTY -041	P/N	DESCRIPTION
X	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-3	ANGLE BRACKET
2	QS20052S	AERO-SEAL CLAMP

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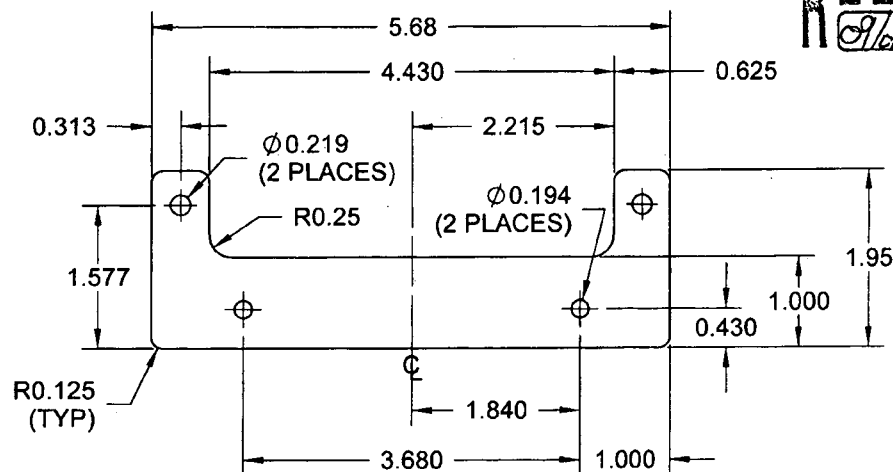
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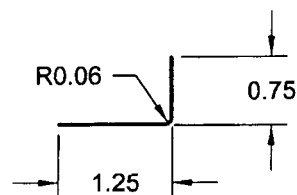
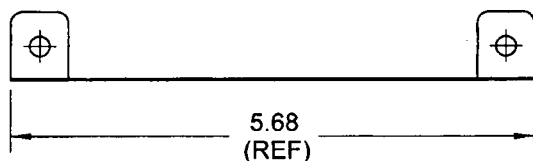
NOTE: Date & initial all entries

DART

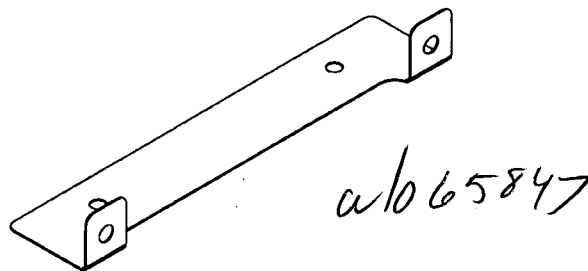
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. B SHEET 3 OF 4
DATE 08.12.19		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2



D3481-1F FLAT PATTERN



D3481-1 ANGLE BRACKET



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH $\triangle B$
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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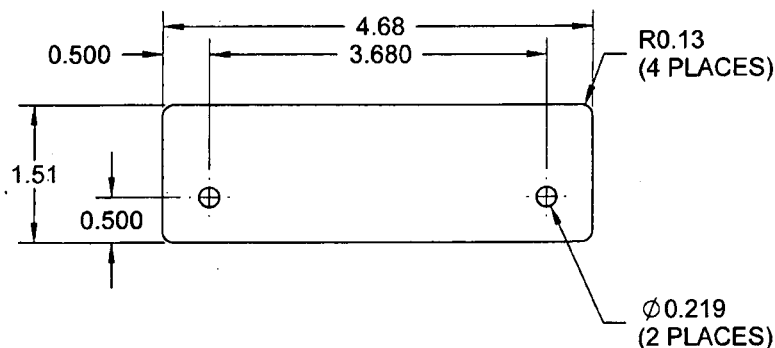
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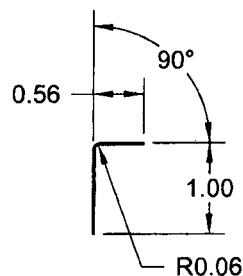
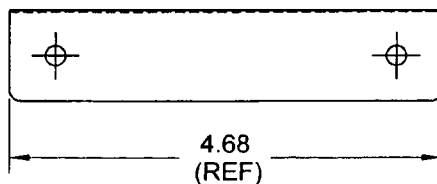


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3481	REV. B SHEET 4 OF 4
DATE 08.12.19		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

RELEASED
07/01/30 *[Signature]*



D3481-3F FLAT PATTERN



w/o 65847

D3481-3 ANGLE BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH \triangle_B
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)
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